Thursday, 4/5/2007 11:59:38 AM Kim Johnston User: **Process Sheet Drawing Name** : SPACER Customer : CU-DAR001 Dart Helicopters Services Job Number : 31704 : 11167 **Estimate Number** : NIA : D32783 **Part Number** P.O. Number s.O. No. : N/A D3278 REV B : 4/5/2007 **Drawing Number** This Issue : N/A : NC Project Number Prsht Rev. : MA : SMALL /MED FAB Type **Drawing Revision** First Issue NIA : 30291 Material Previous Run-: 4/20/2007 50 Um: Each Qty: **Due Date** Written By Checked & Approved By : Est. A 04.04.19 New issue KJ/JLM Comment **Additional Product** الكانسيونيون. Job Number: Description: Seq. #: 🖟 Machine Or Operation: Black Delrin 1.00ml MDELRINS0125X300 diam. ę į N. 5111 Comment: Qty.: 0.0361 sf(s)/Unit Total: 1.8060 sf(s) ·~;\ } Black Delrin 1. J.B. Use DT8685 Router Table. ŧe: Material: Black Delrin/UHMW 0.125" thick 47.14 (M-DELRIN-S0.125x30.0) 7) 4 Identify for D3278-3 SAN 87/06/05 50 Addition - BRICH Batch: 141560 FLOW WATER JET WATER JET 2.0,. (41.47 454 Comment: FLOW WATER JET 1-Cut as per Dwg D3278 Dwg Rev: **Sol** . . 0 SHO 07/06/08 2-Deburr if necessary Tin. INSPECT PARTS AS THEY COME OFF MACHINE 7 3.0 QC2 ... s. بالهجه 60 $C_{P}J$ Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 a. J. North to the 100 Comment: SECOND CHECK 20 67

Page 1

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Form: inrocess

Dart Aerospace Ltd

W /O:				WORK ORDER C	HANGES			, , , , , , , , , , , , , , , , , , , ,	
DATE	STEP		PROC	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
	3								
Part No	: <u>D</u> 317	to-4.	PAR #: NA	Fault Category: Prod (FAB. F.	, MED € SMOLL SS NCR: Ye	s No DQ	A:	│ ∑ Date: <u>○</u>	H06/28
				•		: N/C Close	VIII.	_ Date: <u>C</u>	7106/08 17.06.28

NCR: 31	704	W	ORK OR	DER NON-CONFORMANCI	E (NCR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section B Action Description	Sign &	Verification Section C	Approval Chief Eng	Approval QC Inspecto
>71061 ⁰⁶	2.0	Scrap 51 pieces, because Slats were done, bed was not Level, and evos cassing the offsel to change often	Chief Eng	Chief Eng Scrap - clasting - in place change slot on bend of the water jet	5AD 67/06/06	020607	Osiur	ASOS
e2/oc/27	业2.0	one part (1) scrap. Blow out on back side from when water get perces hale.	Posialz	Scrap Idestory and and no Replace	Aut	Esp OHalelogy	Pasiatz	En offolk

NOTE: Date & initial all entries

Date: User:		nursday, 4/5/2007 11:59:39 AM m Johnston	Pı	rocess Sheet
v	Custome	r: CU-DAR001 Dart Helicopters S	Services	Drawing Name: SPACER
Jol	b Numbe	r: 31704		Part Number: D32783
Job Ni	umber:)
Seq.	#: 4. 2	Machine Or Oper. on:		Description :
and the second	5.0	SMALL FAB 1		MALL & MEDIUM FAB RESOURCE 1
s and the same	Com	nent: SMALL & MEDIUM FAB F 1-C'sink as per dwg D327	RESOURCE 1 8 DOTE	& C'sink the wider side from the water Jet.
e _n th.	44	2-Deburr	mlo7/	c'sink the wider side from the water Jet. 100/21 found 49 in the log SPECT WORK TO CURRENT STEP
سر جادین احتفاد و :	6.0 Sto			Coutable
(2) } (2) }	Çomr	nent: INSPECT WORK TO CUP PACKAGING 1		ACKAGING RESOURCE #1
Suc	- 446 MAP 412 **	nent: PACKAGING RESOURCI Identify and Stock	E#1	
i i i i i i i i i i i i i i i i i i i	- M 2 (c)	Location:	(A)1	7/06/27 48X
	8.0°	QC21	FIN	NAL INSPECTIONWIO RELEASE
4,644	Comr	nent: FINAL INSPECTION/W/O	RELEASE	DO7/66/28
Job Com	pletion			W 07.86.28
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Service de suestine	Safter care.			The second secon
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Page	2			Form: rorocess

Page 2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-07	6.0	Add a vote to Desthe c'sink on the wider side of the bode, where the water set peirces. Derm. Change				020639	Porober
		The diagram					

Part No:	PAR #:	_ Fault Category:	NCR: Yes No DQA:	Date:
			QA: N/C Closed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC	Corrective Action Section B			Verification	Ammerical	A		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
	•								

	STEP	Section A	STEP Section A Initial Chief Eng	STEP Section A Initial Chief Eng Action Description Chief Eng	STEP Section A Initial Chief Eng Chief Eng Sign & Date Initial Chief Eng Ch	STEP Section A Initial Chief Eng Chief Eng Sign & Date Section C	STEP Section A Initial Chief Eng Chief Eng Section C Section C Chief Eng Chi		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31704
Description: Spacer	Part Number:	D3278-3
Inspection Dwg: D3278 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

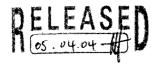
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.98	+/-0.030	2.00			Vern	
1.98	+/-0.030	1.99			Vern	
1.480	+/-0.005	1.482	/		Vern	
0.250	+/-0.010	0.252	/		Vern	
1.480	+/-0.005	1.482			Vern	
Te 0.250	+/-0.010	0.251	/		Vern	
Ø0.098	+0.005/-0.000	\$0.099			Vern	
R0.12	+/-0.030	RO. 12	/		7.5	
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Notes.						
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Measured by:	SAN	Audited by:	Prototype Approval:	N/A
Date:	07106165	Date: 67.06.05	Date:	N/A

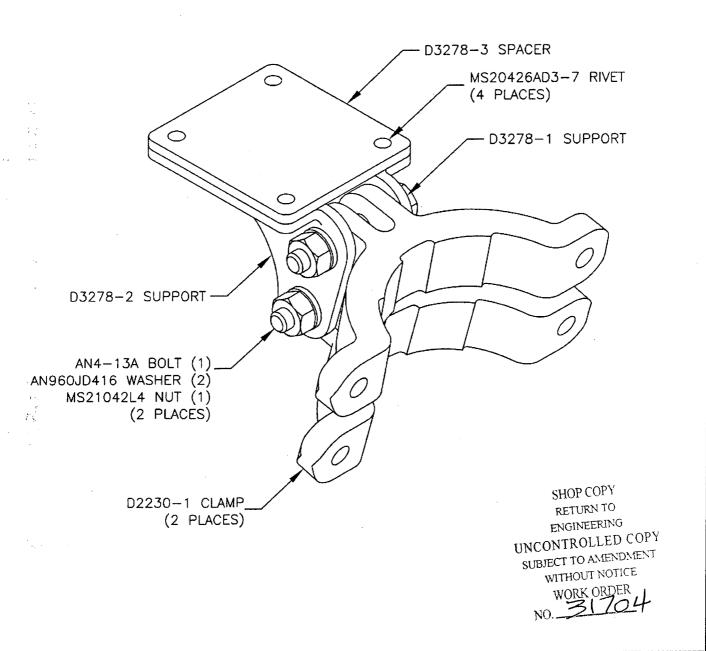
Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue P/O D3278-041	KJ/JLM	
В	06.03.09	Dwg Rev updated	KJ/JLM	1
С	07.02.02	Dwg updated per JLM	KJ/JLM KJ	



	DESIG	CP	DRAWN BY	DART AEROSPACE I HAWKESBURY, ONTARIO, CANADA		
	CHEC	(ED a)	APPROVED	DRAWING NO.		REV. B
		W	4	D3278	SHEET	1 OF 3
ı	DATE			TITLE .		SCALE
	05.0	3.31		SUPPORT ASSEMBLY		NTS
	Α		04.03.03	NEW ISSUE		
	В		05.03.31	CHANGE DIM/TOL TO ENSURE	FIT	



D3278-041 SUPPORT ASSEMBLY

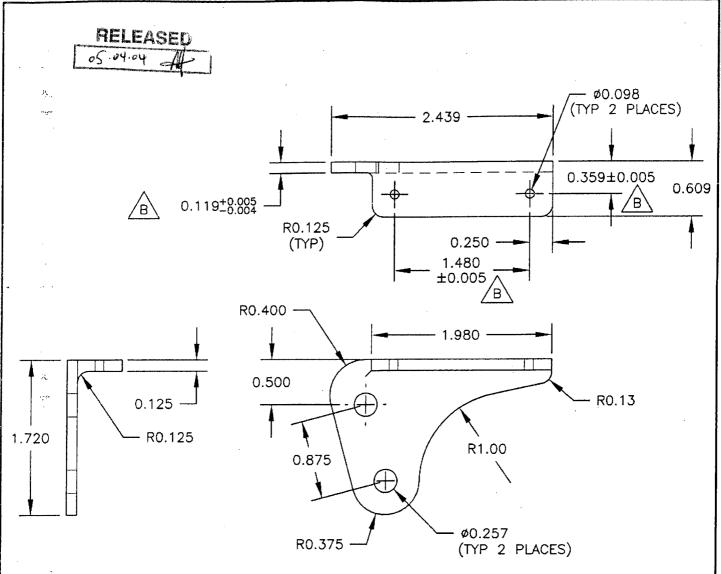


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DESIGN CP	DRAWN BY	DA	RT AEROSPACE LT HAWKESBURY, ONTARIO, CANADA	D
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#	#	D3278	SHE	ET 2 OF 3
DATE	<u> </u>	TITLE		SCALE
05.03.31		SUPPORT	ASSEMBLY	1:



D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

1) MACHINE PER DWG FILE "D3278-1.SLDPRT"

SHOP COPY

2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A_R250/101) **ENGINEERING** (REF DART SPEC. M6061T6B OR M6061T6S)

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

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4) BREAK ALL SHARP EDGES 0.005 TO 0.015

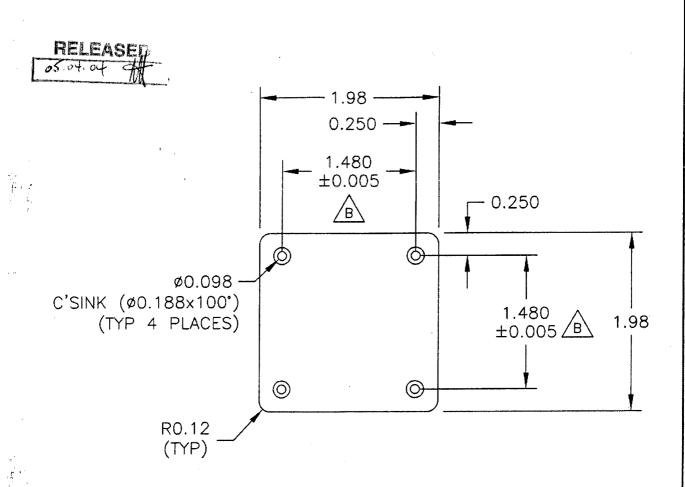
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 6) ALL DIMENSIONS ARE IN INCHES

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	DESIGN CP	DRAWN BY	DA	ART AEROSPACE HAWKESBURY, ONTARIO, CANAD			
1	CHECKED	APPROVED #	DRAWING NO.	_		REV.	В
	#	世	D3278		SHEET	3 OF	3
	DATE		TITLE			SCA	LE
	05.03.31		SUPPORT	ASSEMBLY		•	1:1



D3278-3 SPACER

SHOP COPY

RETURN TO

1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR IMGITERN-S UNCONTROLLED COPY 0.125 THICK

2) BREAK ALL SHARP EDGES 0.005 TO 0.015

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3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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